

Work Order ID 158234

Thursday, March 16, 2017 11:22:29 AM

158234

Page 1

Item ID: D4419-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Support Plate
Start Date: 3/17/2017 Start Qty: 2.00 *?
Required Date: 3/20/2017 Req'd Qty: 2.00 *?
Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 9-99 Date: MAR 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4419	A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.39

(2)17/03/17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.02

(2)17/03/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 158234

Thursday, March 16, 2017 11:22:29 AM

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Page 2

Item ID: D4419-3 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Aft Support Plate
Start Date: 3/17/2017 **Start Qty:** 2.00 ***2*** **Cust Item ID:**
Required Date: 3/20/2017 **Req'd Qty:** 2.00 ***2*** **Customer:**
Reference: SCHEDULED/S

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						2			DAS 38 9-89
QC	Memo	0.04							MAR 21 2017
Quality Control									
130	Identify as per dwg & Stock Location: <u>Stop</u>	0.00							
130						2			DAS 41 9-89
Packaging	Memo	0.02							MAR 21 2017
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									17/3/23
QC	Memo	0.20							
Quality Control									DAS 21 9-89 MAR 22 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By _____
		Lead hand / Supervisor Approval Verification _____
		QC / QA Coordinator Approval _____

Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
☐ OTHER : _____					

Picklist Print

Thursday, March 16, 2017 11:22:32 AM

Page 1

Work Order ID: 158234

158234

Parent Item: D4419-3

D4419-3

Parent Item Name: Aft Support Plate

Start Date: 3/17/2017

Required Date: 3/20/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	31.3100	0.3456	0.727579			

M304S11GA

304/316 0.125 Sheet

on 17/03/17

Location

Loc Qty

Loc Code

MAT020

31.30998

M129545

0.00109

M134604

1.3

M135355

2.80889

M136327

2.7

M136687

24.5

8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

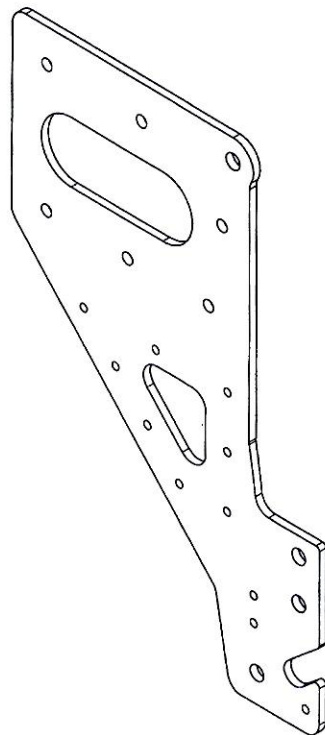
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Root Cause				FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐						Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER :								

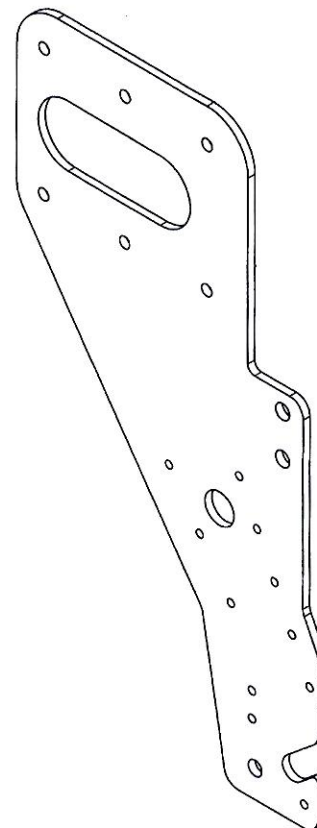
DART AEROSPACE LTD		Work Order:	158234
Description: Aft Support Plate		Part Number:	D4419-3
Inspection Dwg: D4419 Rev: A		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø .128	1			
Ø0.191	+0.005/-0.001	Ø .191	1			
Ø0.250	+0.005/-0.001	Ø .249	1			
Ø0.53	+0.008/-0.001	Ø .53	1			
5.55	+/-0.030	5.55	1			
5.27	+/-0.030	5.27	1			
4.25	+/-0.030	4.25	1			
2.80	+/-0.030	2.80	1			
0.40	+/-0.030	.40	1			
3.83	+/-0.030	3.83	1			
5.56	+/-0.030	5.56	1			
6.26	+/-0.030	6.26	1			
7.14	+/-0.030	7.14	1			
7.73	+/-0.030	7.73	1			
0.31	+/-0.030	.31	1			
0.38	+/-0.030	.38	1			
0.750	+/-0.010	.751	1			
1.53	+/-0.030	1.53	1			
0.390	+/-0.010	.384	1			
0.450	+/-0.010	.450	1			
1.67	+/-0.030	1.67	1			
10.55	+/-0.030	10.55	1			
8.00	+/-0.030	8.00	1			
6.02	+/-0.030	6.02	1			
1.10	+/-0.030	1.10	1			
1.20	+/-0.030	1.20	1			
0.50	+/-0.030	.50	1			
1.500	+/-0.010	1.501	1			
0.60	+/-0.030	.60	1			
2.300	+/-0.010	2.301	1			
0.63	+/-0.030	.63	1			
0.991	+/-0.010	.993	1			
0.440	+/-0.010	.439	1			



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158234

RELEASED
2011-07-28
JW

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

A		NEW ISSUE		AJS	11.07.06
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS				
CHECKED	<i>[Signature]</i>	DRAWING NO. D4419		SHEET 1 OF 3	
MFG. APPR.	<i>[Signature]</i>	TITLE		SCALE	
APPROVED	<i>[Signature]</i>	BASKET SUPPORT PLATES		NTS	
DE APPR.	<i>[Signature]</i>	DATE 11.07.06		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

